

Date: Thursday, 22/01/2009 10:27:10 AM
 User: Melanie Fauteux

Process Sheet

TULMAR

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT D-PAD ASSY
Job Number : 45072	
Estimate Number : 13391	
P.O. Number :	Part Number : PB674300183
This Issue : 22/01/2009 S.O. No. :	Drawing Number : B67-43001 P.12
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 45009	Material :
Written By :	Due Date : 29/01/2009 Qty: 26 Um: Each
Checked & Approved By : <u>MF 09-01-22</u>	
Comment : est rev A new issue 08.06.19 EC verified: DD	



MF 09-01-22

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001185	D-Pad Back Plate
-----	--------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~26~~0000 Each(s)

D-Pad Back Plate

batch: 41566 x 22

B 107387 x 4

MF 09-01-27*gone to balaland*

2.0	PB6743001189	D-Pad Face
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~26~~0000 Each(s)

D-Pad Face

batch: B 41567 x 16, B 44993 x 10MF 09-01-27*gone to balaland*

3.0	PB6743001193	D-Pad Base
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~26~~0000 Each(s)

D-Pad Base

batch: B 41569 x 19, B 44992 x 7MF 09-01-27

4.0	PB6743001339	D-Pad Top
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~26~~0000 Each(s)

D-Pad Top

batch: 41575MF 09-01-27

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld as per dwg B67-43001 (QSI004)

*09-02-05*X26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 10:27:11 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT D-PAD ASSY

Job Number: 45072

Part Number: PB674300183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush only on side of -193

SAN

09-02-06

(26)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD

09-02-06

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters
S 02/02/09 (26)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316

START TIME:

10:45

OVEN TEMPERATURE:

320°

FINISH TIME:

11:15

BL 09-02-10

(26)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

09-02-10

11.0

PG

PURCHASING



Comment: SEND TO TALMAR FOR FOAM AND FABRIC

P10: 8180 C 26/02/11

(26)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

14/3/9

(26)

13.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

counters
S 09/03/05 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 10:27:11 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT D-PAD ASSY

Job Number: 45072

Part Number: PB674300183

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 436 09/13/09

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20
H 09/10.3/06

Job Completion



POSITIVE RECALL

EFFECTIVE 01/05/05

RELEASED LA

MF
09-03-05
DATE 09/13/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

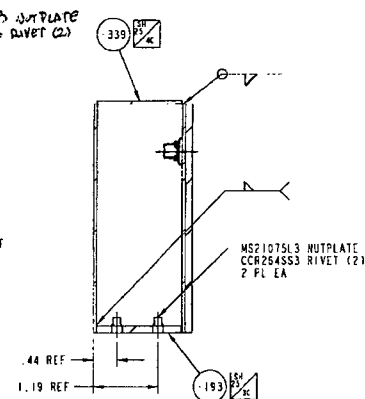
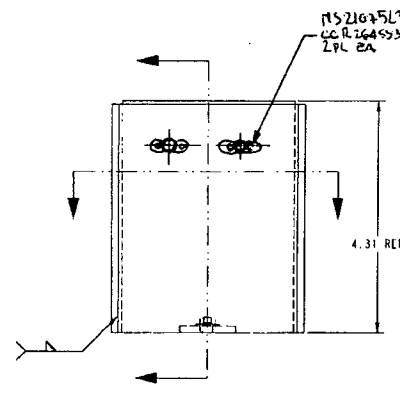
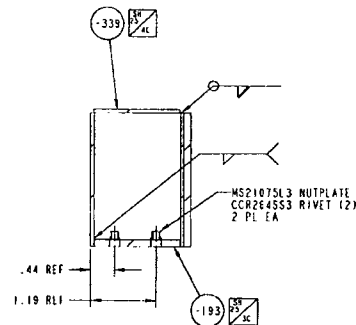
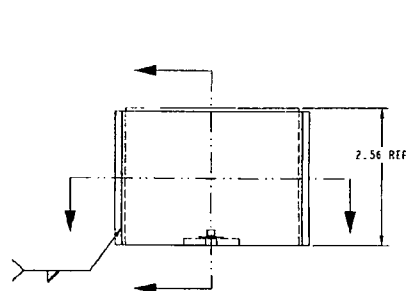
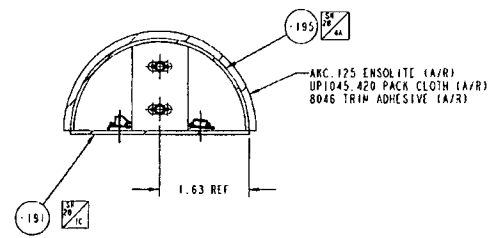
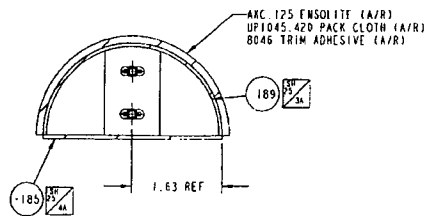
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
4-21-80



⑥ -83 SHORT D-PAD ASSEMBLY
SCALE 1.000

② -85 LONG D-PAD ASSEMBLY
SCALE 1.000

PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75052
SIZE: COMP. INCHES NO. 1000 NO. 1000
D10SUV8 B67-43001
SCALE: 1:1 SHEET: 12 OF 45

ORIGINAL

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : XOTULSAF1123HAW
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No.

31792

Ship Date

4-Mar-09

Ship To:

Dart Aerospace
1270 Aberdeen Street
Buyer: C Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order number :	Sales order date	Account number :	Account manager
22821	12-Feb-09	CDART100	Barney Bangs
PO number		Ship Via	PPD/COL
PO00008180		Pick-Up	
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

8421-101
Dart Blade Fold Kit - Pad #2/
Drawing No: (Ref B67-43001-83 Rev B1)
DWG Rev:NR
Lot No: BATCH0000000005 Qty: 26

26 EA 26

S
9/3/5

Shipper



MAR 04 2009

Date:

Certificate of Conformance

☐ Not Applicable

I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector _____

Date: 03/04/2009

FAXED
11-5-08**CLIFTON**
Adhesive, Inc
Industrial Adhesives & Coatings

Date: 11/4/08

Shipper #: 11489

Certificate of Compliance

This letter certifies that 11 x 5 gallon pails of LA4009 Adhesive,
lot number (s) 08-294 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 10/20/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/20/09

This letter certifies that 5 x quart cans of CATUR Accelerator,
Lot number 08-305 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 10/31/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/31/09

Sincerely,

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Burgess Place • Wayne, NJ 07470 USA
Phone: 973-694-0845 • Fax: 973-694-5678
www.cliftonadhesive.com

7122/24. (62)



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 9, 2008

Fax To: Tulmar Safety Systems

Fax: 613-632-2030

Attention: Sandra Nadeau

Fax From: Sharon James

EDMONTON

HEAD OFFICE

12122 - 68 Street
Edmonton, AB T5B 1R1
Canada
Phone: (780) 474-5721

Certificate of Conformance

Re: PO 14881-00 for Oxford 7 Black

The goods shipped on P/O 14881-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

CALGARY

2nd Floor, 337 - 17 Avenue SW
Calgary, AB T2S 0A5
Canada

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

VANCOUVER

13911 Bridgeport Road
Richmond, BC V6V 1J6
Canada

Manufacture Date: 08/06/08

Lot Number: 35896

Sincerely,
J. Ennis Fabrics Ltd.

S James

MONTREAL

9280 boulevard du Golf
Anjou, QC H1J 3A1
Canada

Sharon James
Product Development

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

NO. 355 P. 2

J ENNIS FABRICS LTD

OCT. 9. 2008 1:09PM

41/5941 #55

frmGovernment

Page 1 of 2



American & Efird Inc.
Post Office Box - 507
Mount Holly, NC -28120

Test Report

Date : 1/26/2009

QLL No. 844

Mfg. Date : 1/12/2009

Quantity: 16.9

Lot Id : 566518

Product : Tex 90 BONDED 'Z' NYLON FILAMENT Black AA 63002 16 OZ

Specification : VT295E TPII CLA F BT92N4

Customer Order Number : 15245-00

Plys (Visual) : 4

Customer : Tulmar Safety

Twist Direction : Z

Shipped To : Tulmar Safety

A&E Color : 63002 Black
AA

Characteristic	Test1	Test2	Test3	Test4	Test5	Average	Minimum	Maximum
Strength #1 (Pound)	15.2	15.3	14.8	15.3	15.3			
Strength #2 (Pound)	15	14.9	15	15.1	15.1			
Average Strength (Pound)						15.1	11.8	

Elongation #1 (Percent)	21.9	22.4	21.3	22.3	22.1			
Elongation #2 (Percent)	21.8	21.5	22.3	21.9	21.7			
Average Elongation (Percent)						21.9		26

Twist S #1 (Turns per inch)	12.3							
Twist S #2 (Turns per inch)	12.3							
Average Twist S (Turns per inch) Initial Twist						12.3		

Twist Z #1 (Turns per inch)	8.2							
Twist Z #2 (Turns per inch)	8.2							
Average Twist Z (Turns per inch) Final Twist						8.2	5.5	

Yield #1 (Yards/Pound)	4077.2							
Yield #2 (Yards/Pound)	4126.1							
Average Yield (Yards/Pound)						4101.6	3600	5200

Shade Evaluation : GOOD
 Laundering : GOOD
 Perspiration : GOOD

frmGovernment

Page 2 of 2

Wet Dry Cleaning :	<u>GOOD</u>
Light Test :	<u>GOOD</u>

I certify that the above test were performed under my supervision and in accordance with the specification test requirements and that the reported test results are true, valid and applicable to the samples tested. I further certify that these samples were the only samples tested from the lot of components identified above.

Signed : *Scott D. Munday*
Testing Director



This Certificate of Compliance is the property of American & Efird Inc. and may not be reproduced except in it's entirety.

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

Date : 07/15/2005

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

FOURNISSEUR
VENDOR

E.F. WALTER INC.
5000 HICKMORE
ST. LAURENT, PQ
H4T 1K6

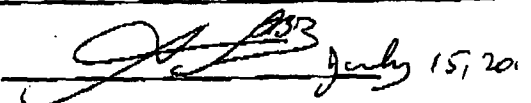
Commande / Order # 10280

Notre / Our Reference # 37736

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Piece # Part #	Description
742050004	10.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/2" X 42" X 72' (NO SKIN) ASTM D1056 2A2
742012002	5.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/8" X 42" X 72' (NO SKIN) ASTM D1056 2A2
			FLAME RESISTANCE
			SERVICE TEMP -40 DEG F TO +200 DEG F

Signé
Signed


EC #1637-001/01 (C)

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

Date : 09/09/2008

FOURNISSEUR
VENDOR

E.F. WALTER INC.
180 BARTOR ROAD
TORONTO, ONTARIO
M9M 2W6

Commande / Order # 14649-00

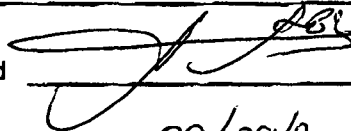
Notre / Our Reference # 55968

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050005	8.000 PCS	# 1637-001	SPONGE NEOPRENE BLACK SC42 TRIMMED NO SKIN (1/2" x 54" x 72") ASTM D1056, 2A2
			LOT # 75570 MANUFACTURING DATE: Sept. 5, 2008

Signé
Signed



09/09/2008

Tsc # 1637-001/02